

Work Order ID 59233 -2

Friday, May 28, 2010 9:48:50 AM

SRIT



Page 1

Item ID: D3405-043

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 5/27/2010

Start Qty: 8.00

Required Date: 6/4/2010

Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-5-28

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100



Waterjet

FLOW CNC Waterjet

304 125

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

IB 10-6-3

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

IB 10-6-3

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sublog/03

(HLL)

Work Order ID 59233

Friday, May 28, 2010 9:48:50 AM



Page 2

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 5/27/2010 Start Qty: 8.00



Required Date: 6/4/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Debur

Form using DT8204 as per Dwg D3405

0.00

0.00

SS 10/06/07

(16)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/06/07

(16)

150



Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 use DT9625
Identify as D3405-043

0.00

0.00

EL 10-6-22

(x2)

Work Order ID 59233

Friday, May 28, 2010 9:48:50 AM



Page 3

Item ID: D3405-043

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 5/27/2010 Start Qty: 8.00

Required Date: 6/4/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Cpl 10-06-22

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/06/02

(x2)

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:25
400°
9:55

(2) 8/10-6-23

Work Order ID 59233

Friday, May 28, 2010 9:48:50 AM



Page 4

Item ID: D3405-043

Revision ID:

Item Name: Lug Assembly

Accept



Setup Start



Stop



Start Date: 5/27/2010 Start Qty: 8.00



Required Date: 6/4/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

10-6-23

20 SP

200



Packaging

Packaging

Identify as per dwg & Stock Location: 474

0.00

Memo

0.00

10-6-23

20 SP

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/24 SP

CX 10/06/24

Picklist Print

Friday, May 28, 2010 9:48:54 AM

Page 1

Work Order ID: 59233

Parent Item: D3405-043

Parent Item Name: Lug Assembly

Comments: IPP A 05.09.01 New issue (KJ/JLM)
IPP B 09.01.28 Rev b dwg EC verified by: DD

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 8.00

Required Qty: 8.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3404-I | | Manufactured | No | | | 100 | Each | 30.0000 | 1 | 8 | | | |

GHW Lug

B 59591 x 2

Location

Loc Qty

Loc Code

WA

30

56832

10

57927

20

Purchased

No

150

sf

35.9300

0.154

1.296842

1.7

B 10-6-3

Location

Loc Qty

Loc Code

MAT

35.93

114488

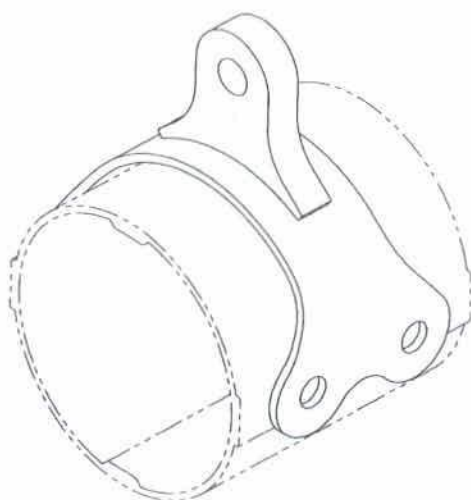
35.93

114488

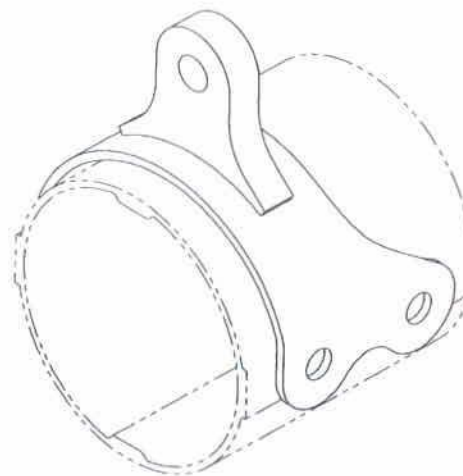
M304S11GA

304/316 0.125 Sheet

| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|-----------|-----------|-------------|--------------|
| 1 | X | | D3405-041 | LUG ASSEMBLY |
| 2 | | X | D3405-043 | LUG ASSEMBLY |
| 11 | 1 | 1 | D3404-1 | GHW LUG |
| 12 | 1 | | D3405-1 | GHW BRACKET |
| 13 | | 1 | D3405-3 | GHW BRACKET |



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHIPPING COPY
RETURNED
ENCLOSURE
UNCLASSIFIED BY 1000
SUBJECT TO CANCELLATION
WITH NO FURTHER
WORK ORDER
NO. 58233

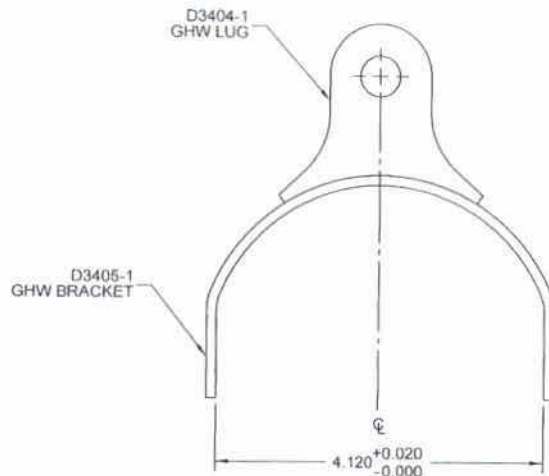
Pl 10-5-23

RELEASED
08/12/18 M.F.

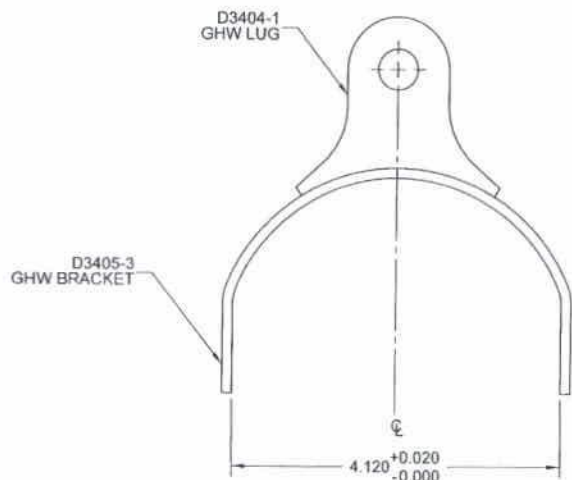
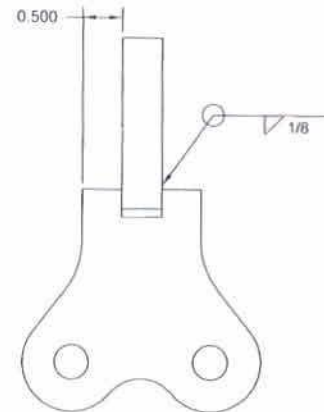
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

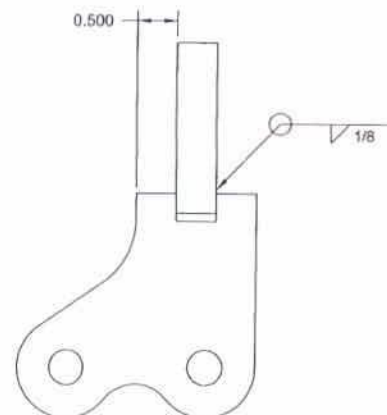
| | | | | |
|------------|---|-----------------------------|--|----------|
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART 198) SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. | | AJS | 08.09.19 |
| A | NEW ISSUE | | PH | 05.03.08 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD | | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | | DRAWING NO. | REV. B | |
| MFG. APPR. | | D3405 | SHEET 1 OF 4 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GHW LUG ASSEMBLY | NTS | |
| DATE | 08.09.19 | | <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> | |



D3405-041 LUG ASSEMBLY



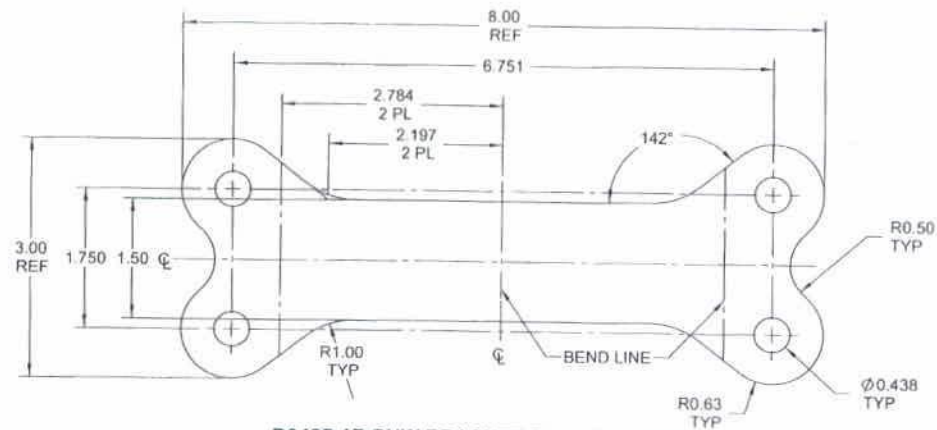
D3405-043 LUG ASSEMBLY



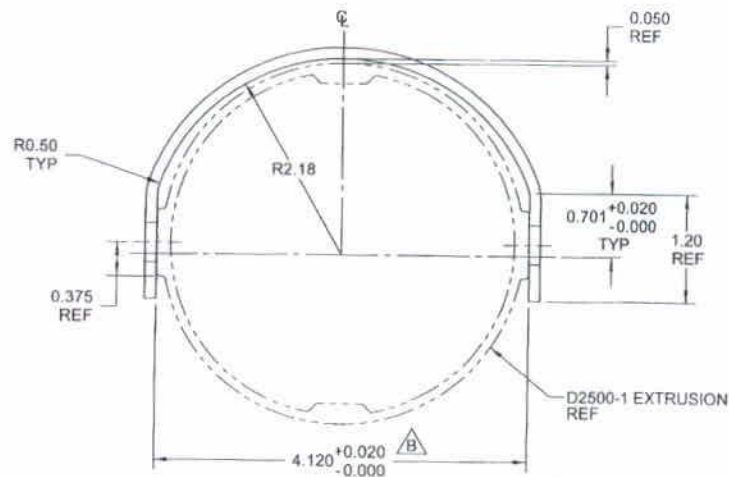
w/o 59233

RELEASED
06/12/18

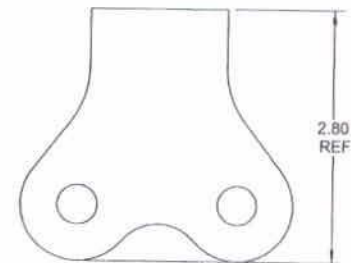
| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
| DATE | 08.09.19 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> | |



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

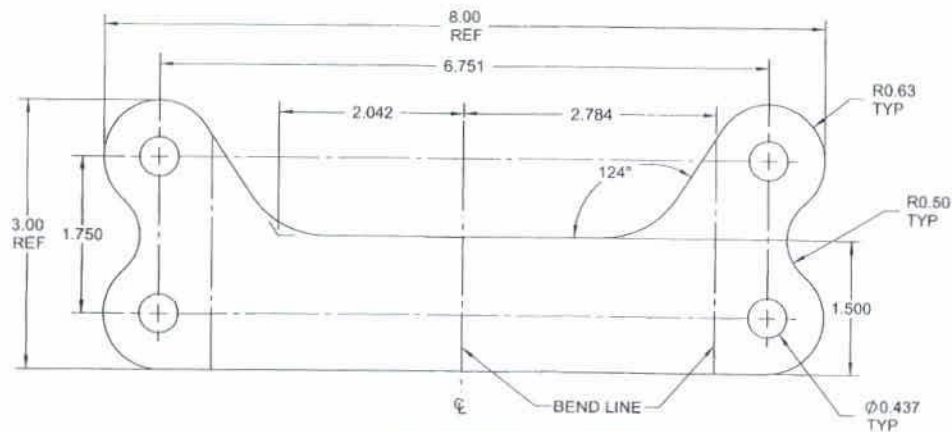
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

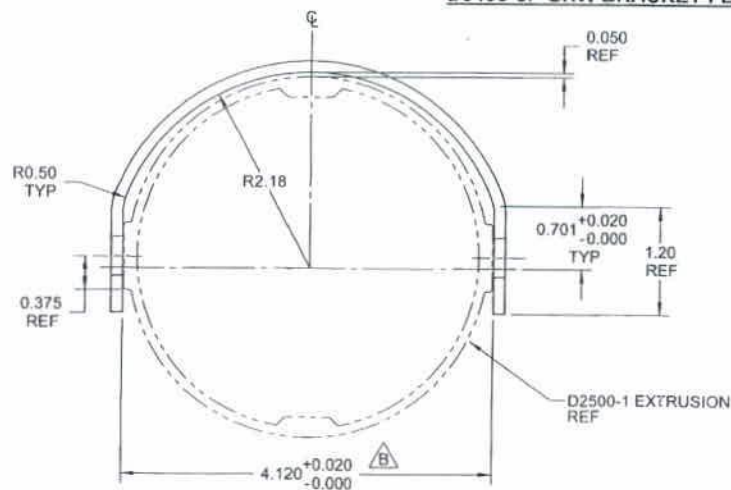
| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
| DATE | 08.09.19 | COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

W/059233

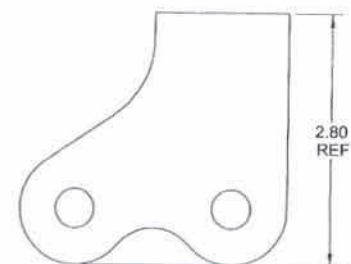
RELEASED
MP 28/12/13



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

w/c 59233

RELEASED
06/12/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
| DATE | 08.09.19 | COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED IN COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |